

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
690 Walnut Ave. St. 150
Vallejo, CA 94592-1133
(707) 649-5453
(707) 649-5493

Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 1x.28**WELDING INSPECTION REPORT****Resident Engineer:** Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-014073**Date Inspected:** 14-May-2010**Project Name:** SAS Superstructure**OSM Arrival Time:** 1230**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1600**Contractor:** American Bridge/Fluor Enterprises, a JV**Location:** Job Site**CWI Name:** Bernard Docena**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG Sections**Summary of Items Observed:**

This Quality Assurance (QA) Inspector, Craig Hager was on site at the job site between the times noted above. This QA Inspector was on site to randomly observe Quality Control (QC) personnel perform Non-Destructive Testing (NDT) and to monitor American Bridge/Fluor (ABF) welding operations.

The following observations were made:

- 1) At weld joint E5/E6 – A1 thru A5: ABF welding personnel Rick Clayborn (#2773) was using the Shielded Metal Arc Welding (SMAW) process during the fit up of the weld joint with QC Inspector Bernard Docena present.
- 2) At weld joint E3/E4 – C1 and C2: ABF welding personnel Mitch Sittinger (#0315) was using the SMAW process to perform repair welding with QC Inspector Tony Sherwood present.
- 3) At weld joint E3/E4 – C1 and C2 QC Inspector tony Sherwood performed a visual Magnetic Particle Testing (MT) at areas where temporary welds had been removed.

At weld joint E5/E6 – A1 thru A5 this QA Inspector randomly observed ABF welding personnel Rick Clayborn using the SMAW process to fillet weld fitting aids such as “dogs” during the fit process. This QA Inspector randomly observed QC Inspector Bernard Docena monitoring the welding. This QA Inspector randomly observed QC Inspector Bernard Docena verify the preheat temperature was greater than 70° C prior to welding and the following welding parameters when welding started: 118 amperes with a 3.2 mm diameter E7018 electrode. The welding observed appeared to comply with Welding Procedure Specification (WPS) ABF-WPS-D15-F1204.

At weld joint E3/E4 – C1 and C2, outside this QA Inspector randomly observed ABF welding personnel Mitch

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Sittinger (#0315) using the SMAW process to perform repair welding. This QA Inspector randomly observed QC Inspector Tony Sherwood monitoring the welding parameters. This QA Inspector randomly observed QC Inspector Tony Sherwood verify the following welding parameters: 123 amperes with a 3.2 mm diameter E7018 electrode. The welding observed appeared to comply with WPS - ABF-WPS-D15-1001-Repair.

At weld joint E3/E4 – C1 and C2 this QA Inspector randomly observed ABF welding personnel Mitch Sittinger (#0315) had suspended performing SMAW and was informed that all repairs that could be completed from the outside had been done and that he would be relocating upon informing his foreman. This QA Inspector was informed by QC Inspector Tony Sherwood that 6 of the 13 repairs on this weld had been completed. This QA Inspector randomly observed as QC Inspector Tony Sherwood performed a visual and MT inspection of the areas where temporary welds had been used to attach fitting aids. QC Inspector Tony Sherwood stated he had marked several areas where arc strikes needed to be removed and additional welding to fill grind areas. This QA Inspector performed a random visual verification the work observed appeared to comply with the contract requirements.

Summary of Conversations:

As noted above.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Mohammad Fatemi (916) 813-3677, who represents the Office of Structural Materials for your project.

Inspected By:	Hager,Craig	Quality Assurance Inspector
Reviewed By:	Levell,Bill	QA Reviewer
